

January-26-12 1:07:52 PM

Page 1

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79474

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 26/01/2012 **Start Qty:** 8.00 ***8***

Cust Item ID:

Required Date: 09/02/2012 **Req'd Qty:** 8.00 ***G***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

NC BRAKE

0.00

Brake NC

Memo

Brake NC

Bend per Dwg D2353

SB 12/03/18

10

140

0.00

140

QC5- Inspect part completeness to step on W/O

0.00

OC

Memo

Quality Control

150

0.00

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

Hand Finishing

8.2/03/15

(F10)

10x of M-12/03/15

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Work Order ID 79474

79474

Page 3

January-26-12 1:07:52 PM

Item ID: D2353 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Stiffener
 Start Date: 26/01/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 09/02/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo START TIME: <u>10h05</u> OVEN TEMPERATURE: <u>10h35</u> FINISH TIME: <u>320°F</u>	0.00 0.00				10	8	20/12/03/16	
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00						10X/12/03/16	
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST228</u> Memo	0.00 0.00						Q 12-03-20 12/3/17	

12-03-16

Dart Aerospace Ltd

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NOTE: Date & initial all entries

79474

Page 4

N900040100

Setup Start *NS1*

Stop ***NS2***

8

8

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

0.00

190

QC

Memo

0.00

Quality Control

12/3/19 JJ

Dart Aerospace Ltd

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Picklist Print

January-26-12 1:07:57 PM

Page 1

Work Order ID: 79474

79474

Parent Item: D2353

D2353

Parent Item Name: Stiffener

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev: A Removed from 9 Digit 05-11-10 EC
IPP: B 06.11.15 waterjet EC
IPP: c 06.12.07 ecn 836 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	68.6000	0.1463	1.232			

M2024T3S 050

2024-T3 .050 sheet

**

HS 12-3-9

Location

Loc Qty

Loc Code

MAT022

68.6

117684

68.6

117684

10

Dart Aerospace Ltd

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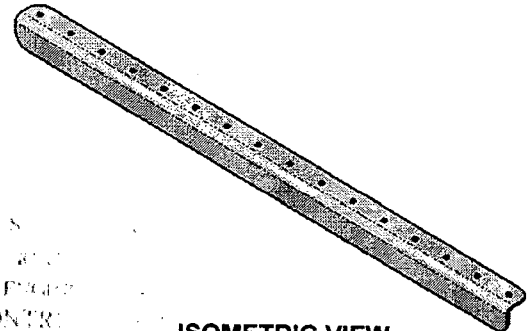
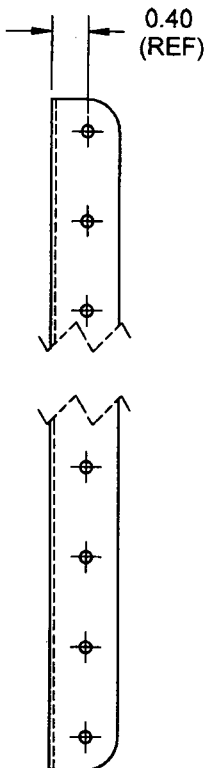
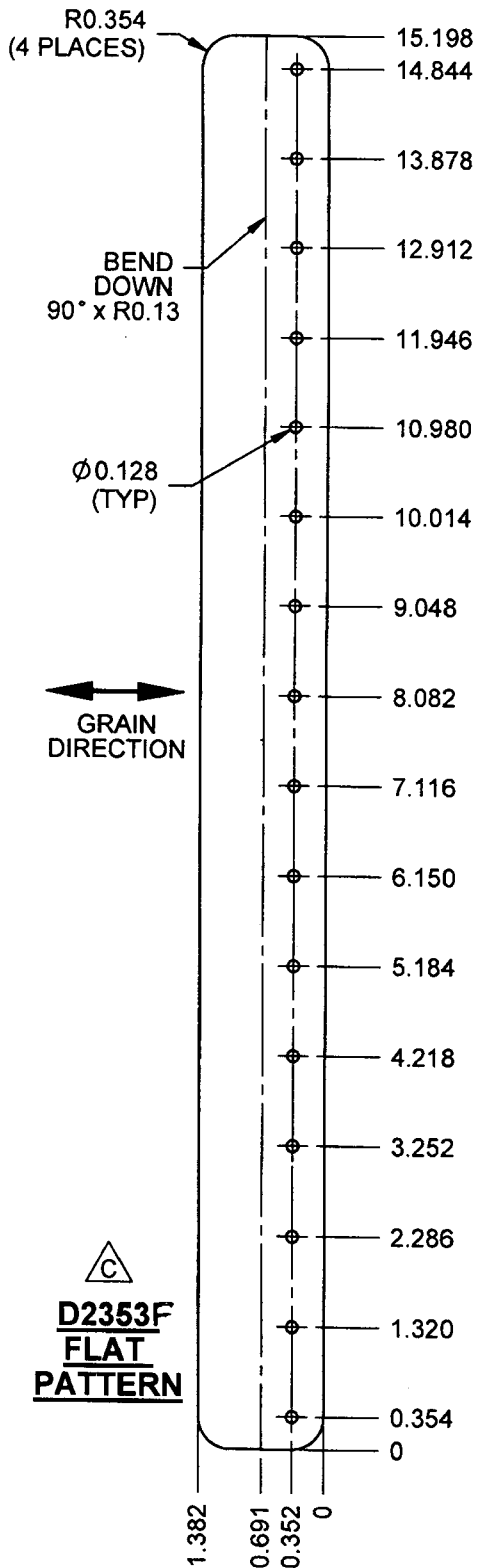
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DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2353	REV. C SHEET 1 OF 1
DATE 06.11.13	TITLE STIFFENER		
REV		DATE	DESCRIPTION
B		95.02.23	ADD TEXT
C		06.11.13	ADD FLAT PATTERN; ADD NOTES; UPDATE DWG



ISOMETRIC VIEW
SCALE 1:4

UNCONTROLLED
SUBJECT TO
WITH
WORK
NO. 79474 H.L.J.
12/01/26

- NOTES:
- 1) MATERIAL: ALUMINUM 2024-T3 SHEET, 0.050 THICK
PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T4S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7)
PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
 - 4) IDENTIFY WITH DART P/N "D2353" USING A WHITE
FINE POINT PERMANENT INK MARKER
 - 5) ALL DIMENSIONS ARE IN INCHES UNLESS
OTHERWISE NOTED
 - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

**D2353F
FLAT
PATTERN**

**D2353
BEND DETAIL**

RELEASED
06-11-28 [Signature]

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